

Date: Thursday, 02/04/2009 2:25:50 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: MOUNTING LUG		
Job Number	: 46849			Part Number	: D30401		
Estimate Number	: 11534			Drawing Number	: D3040 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 02/04/2009	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 20/04/2009		
Previous Run	: 42944			Qty:	10	Um:	Each
Written By	:						
Checked & Approved By	: <u>JLD 09.04.02</u>						
Comment	: Est:B 01.11.08 Revised Step 2 and Added Inspection Level 21 S M Est Rev:C Now on WaterJet 07-03-07 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0187X04000	6061-T6 Bar .178 x 4.00	
Comment: Qty.: 0.3718 f(s)/Unit Total : 3.7181 f(s) 6061-T6 Bar .178" x 4.0" Material: 6061-T6 alum plate 0.188" thick <u>BB 9-4-6</u> Batch: <u>106 652</u>			
2.0	WATER JET	FLOW WATER JET	
Comment: FLOW WATER JET 1-Cut as per Dwg D3041 Dwg Rev: <u>B</u> <u>BB 9-4-6</u> Prog Rev: <u>B</u>			
2-Deburr if necessary <u>BB 9-4-6</u> <u>M-1</u> <u>09/04/07</u> <u>12</u> <u>12X</u> <u>PTC</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
<u>BB 9-4-6</u>			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
<u>BB 9-4-6</u> <u>09/04/07</u> <u>12</u>			
Comment: SECOND CHECK			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>WA18</u> <u>BB 09.04.07</u> <u>12</u>			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3040-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 09/04/07

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 46849		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/07	2.0	Draft holes open + holes are slightly under size from w. J. which is a good thing.  R.C.: Jet off set.	NSK0012	- drill open holes to 0.257" as per drawing. debur all edges + holes	M-L 09/04/07	16/04/07	09/04/07	16/04/07

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 46849

Part Number: D30401

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



09/04/08 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-07

W/O:		WORK ORDER CHANGES					Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	4008P
Description: Mounting Lug	Part Number:	D3040-1
Inspection Dwg: D3040	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

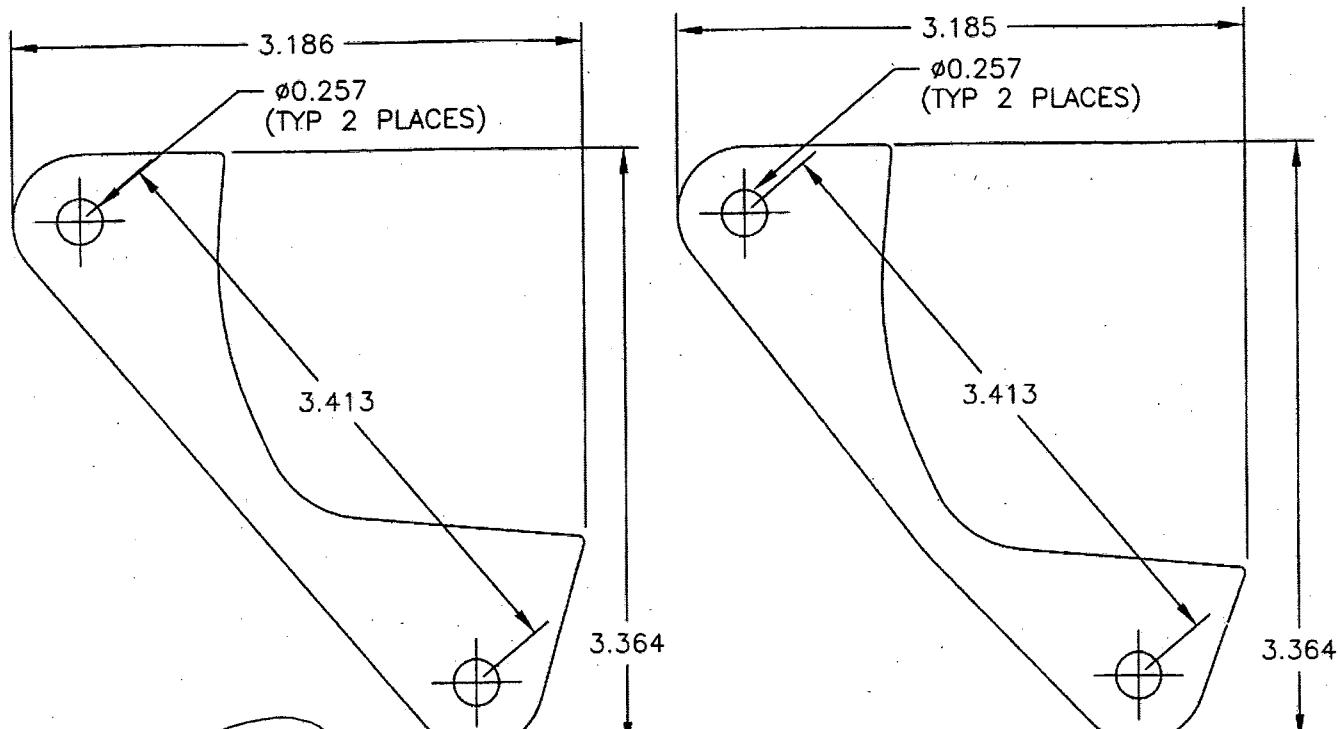
## X First Article      Prototype

Measured by: <u>BS</u>	Audited by: <u>/</u>	Prototype Approval: N/A
Date: 9-4-04	Date: 09-01-07	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	8

**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3040 REV. B SHEET 1 OF 1
DATE		TITLE MOUNTING LUG SCALE 1:1
01.09.04		
A	01.06.27	NEW ISSUE
B	01.09.04	CHANGED PROFILE 5 DEGREES

**RELEASED**  
01.09.07**NOTES**

- 1) MACHINE PARTS PER DRAWING FILE "D3040-B1.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK  
(REF M6061T6S.188)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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NO. 4084